

Date: Friday, 30/11/2007 1:01:37 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36085
Estimate Number : 12812
P.O. Number : N/A
This Issue : 30/11/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 32832
Written By :
Checked & Approved By :
Comment : est rev A new issue 07.03.28 EC
est rev B released, changed mat'l EC

Drawing Name : BRACKET

Part Number : D3610041
Drawing Number : D3610 REV.A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 07/12/2007

Qty: 20 Um: Each

Nac 24

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4140NB1500X15000 AISI 4140 Steel Bar



Comment: Qty.: 0.5775 f(s)/Unit Total : 11.5500 f(s)
AISI 4140 Steel Bar

2.0 BAND SAW BAND SAW NO MATL. in computer



Comment: BAND SAW Batch M106451 X20
Cut blank 6.600 " long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A

2-Deburr per dwg D3610

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.12.07

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nutplate

Batch:

M106576

no quantity

AS 07/12/18

(x4)

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

RIVET

batch:

M102404

AS 07/12/18

(x4)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet Nut Plate as per Dwg D3610

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07-12-20

(4)

08/01/03

(x4)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 244

[Signature]

AS 07/12/18

x4

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

2008/10/04

Job Completion



mini 2008/1/4

[Signature]

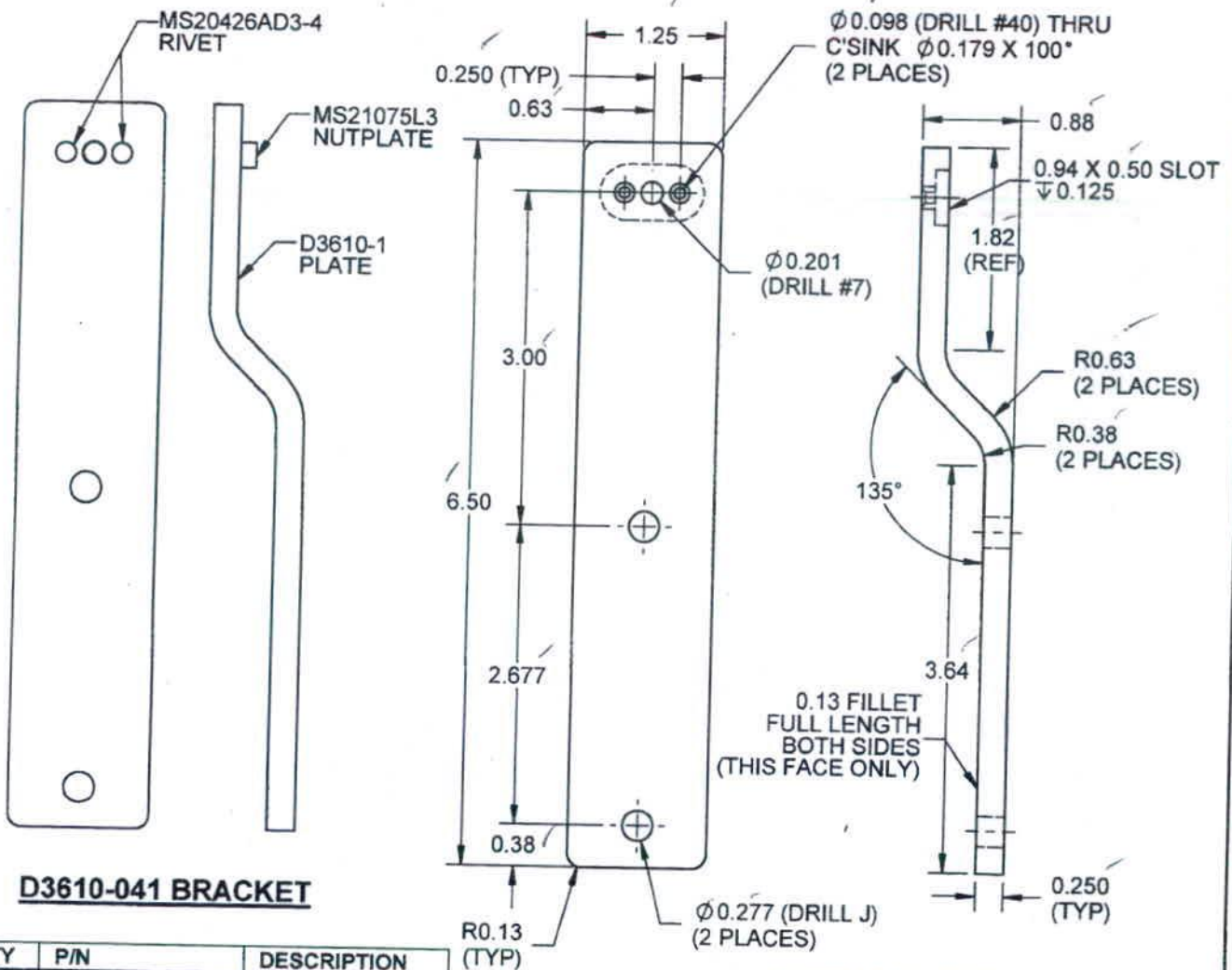
POSITIVE RECALL

EFFECTIVE 02/12/12 AUTH *[Signature]*

RELEASED *[Signature]* DATE 08/07/14

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET SCALE 2:3		
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

RELEASED07.04.25 *[Signature]***D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 36085
Description: bracket		Part Number: D361004
Inspection Dwg: D3610	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+ .030	1.247	✓			
.250	+ .010	.250	✓			
Ø .098	+ .005 - .001	.100	✓			
.63	+ .030	.624	✓			
Ø .201	+ .005 - .001	.204	✓			
6.50	+ .030	6.498	✓			
3.00		2.998	✓			
2.677	+ .010	2.677	✓			
.38	+ .030	.373	✓			
5.130	+ .030	.130	✓			
.277	+ .005	.279	✓			
.88	+ .030	.879	✓			
.44X.50	+ .030	.911X.501	✓			
1.82		1.827	✓			
3.64	+ .030	3.648	✓			
.250	+ .010	.250	✓			
1350	+ 1/2°	1350	✓			
↓ .65	+ .010					

Measured by: J.L.	Audited by: S.F.	Prototype Approval:
Date: 07/12/06	Date: 07/12/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

